

Date: Monday, 3/26/2007 3:25:16 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP INSTALLATION KIT
Job Number	: 31493		
Estimate Number	: 10542		
P.O. Number	: <i>N/A</i>	Part Number	: K591113
This Issue	: 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D350-591 REV F PG17
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 30868	Material	: <i>N/A</i>
Written By	:	Due Date	: 5/2/2007 Qty: 12 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: C 04.11.09 Reformat KJ/JLM		

Additional Product

Job Number: 

Seq. #: Machine Or Operation: - - Description :

1.0 D2171 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Clamp

Pick:

Qty	Part Number	Description	Batch
2	D2171	Clamp	<i>B29085</i>

2.0 D2182B Neoprene Cushion-.750 bl



Comment: Qty.: 0.5833 f(s)/Unit Total : 6.9996 f(s)

Neoprene Cushion-.750 bl

Pick:

Qty	Part Number	Description	Batch
7"(2 x 3.5")	D2182B	Cushion	<i>B30397</i>

3.0 D2274 Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Radius Block

Pick:

Qty	Part Number	Description	Batch
4	D2274	Radius Block	<i>B30518</i>

4.0 D23623 Step Support Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Step Support Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2362-3	Support Bracket	<i>B30877</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Daté & initial all entries

Date: Monday, 3/26/2007 3:25:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 31493

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 7.2000 f(s)

Abrasion Strip

Pick:

Qty Part Number Description Batch

7.2" (QTY 1) D2856-400 Abrasion Strip

1329850 ✓

6.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3-37A Bolt

M103926 ✓

7.0

AN420A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

4 AN4-20A Bolt

~~M116877~~ M116895 ✓

8.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

1 AN4-22A Bolt

M100771 ✓

9.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 AN960JD10 Washer

M103641 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:25:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 31493

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Washer

Pick:

Qty Part Number Description
6 AN960JD416 Washer

Batch

M102929

11.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

Qty Part Number Description
2 MS21042L3 Nut

Batch

M103914

M102658

12.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Pick:

Qty Part Number Description
5 MS21042L4 Nut

Batch

M102658

M103914

JAN 07/04/02

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PO 8/4/9

SAN 07/04/02

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/11

Job Completion



U 07-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
8	4	4	4	4		AN4-20A	BOLT
1	1	1		1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	6	4	6	14	AN960JD416	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31493

• COPYRIGHT © 1993 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: F

Date: 04.03.02